



DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2354	REV. D SHEET 1 OF 2
DATE 05.11.14		TITLE LOW SHORT STEP ASSEMBLY	SCALE NTS
A	95.02.14	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

D2354 LOW SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2354	Low Short Step Assembly	X
D2244-59.4	STEP EXTRUSION*	1
D2275	BUSHING	1
D2643-1	STEP LEG ASSEMBLY	1
D2643-2	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	RIVETS	12



*cut per drawing


RELEASED
05.11.28 [Signature]

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FACE TOP OF STEP ON CENTER WITH BUSHING USING $\phi 1.875$ FACING TOOL FACE TO REMOVE RIDGES ON EXTRUSION

DRILL HOLE THROUGH EXTRUSION TO FIT $\phi 1.25$ BUSHING WELD BUSHING INTO HOLE WITH COUNTER BORE FACING UP

D2275 BUSHING

59.34
LENGTH OF EXTRUSION WITHOUT END CAPS

51.806
BUSHING CENTER TO FURTHEST LEG RIVET HOLE

D2673-34

D2244

56° (TYP)

DRILL $\phi 0.128$ ON BOTH SIDES OF D2244 TO MATCH D2643-1/-2 HOLE PATTERN RIVET D2643-1/-2 TO D2244 USING MS20600AD4W3 (TYP. 12 PLACES)

0.25

0.60

2.25 TYP

3.10 (MEASURED BEFORE END PLATE IN PLACE)

TYPICAL

D2643-1
STEP LEG ASSEMBLY

D2643-2
STEP LEG ASSEMBLY

STEP LEG DETAIL

D2354 LOW SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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